

Ship March 6 - Thurs

Work Order ID 114017

114017

Page 1

Item ID: D3319-1 **D 3 3 1 9 - 1** Accept ***N19000040100*** Setup Start ***NS1***
 Revision ID: **B 1 1 4 0 1 7** Stop ***NS2***
 Item Name: Forward Wearplate
 Start Date: 3/03/14 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 3/06/14 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3319	C

100	FLOW WATER JET	0.00				14	0		Jm14-03-3
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3319 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Debur if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				14	0		Jm14-03-3
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				14			
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

14/3/3

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Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Forward Wearplate
Start Date: 3/03/14 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 3/06/14 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	NC BRAKE	0.00							
140									
Brake NC	Memo	0.00		DAS		14			14/03/03
Brake NC	1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: <u>C</u>			30					
	2- Form flat on press using DT8776 block			9-89					
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00		DAS		14			
Quality Control				27					
				9-89					
160	Weld per dwg A/R Hardcoat steel Batch: <u>1124434</u>	0.00							
160									
Large Fab	Large Fab	0.00				14			14/03/05
Large Fab	Memo	0.00							
	1- Layout weld location as per Dwg D3319 using jig D3319-1T3								
	2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: _____								
	Qty Part Number Description Batch								
	A/R N/A 228/7560 Hardcoat Rod _____								

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Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Forward Wearplate
 Start Date: 3/03/14 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 3/06/14 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				(14)	14-03-05		DAS 9 9-89
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(14)	14-03-05		DAS 9 9-89
190 *190* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 7:30am OVEN TEMPERATURE: 320°F FINISH TIME: 8:00am	0.00 0.00				x14	g/	all 14/03/05	

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Item ID: D3319-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Forward Wearplate
 Start Date: 3/03/14 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 3/06/14 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		DAS 27 9-89 14/3/6		14			
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: ST550 Packaging Memo Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: _____	0.00 0.00				14x		14-3-6	DAS 26 9-89
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						14-03-6	

14-03-06

Picklist Print

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Work Order ID: 114017

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Parent Item: D3319-1

D3319-1

Parent Item Name: Forward Wearplate

Start Date: 3/03/14

Required Date: 3/06/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B05.10.14Added step 9, dwg rev B KJ/EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	sf	105.6709	0.628	7			
M1010S18GA									**		Jm14-03		
1010/1025 SHEET .048													

Location

Loc Qty

Loc Code

MAT019

105.6709

116268

0.970948

117806

18

124428

31

m127805

55.7

127805

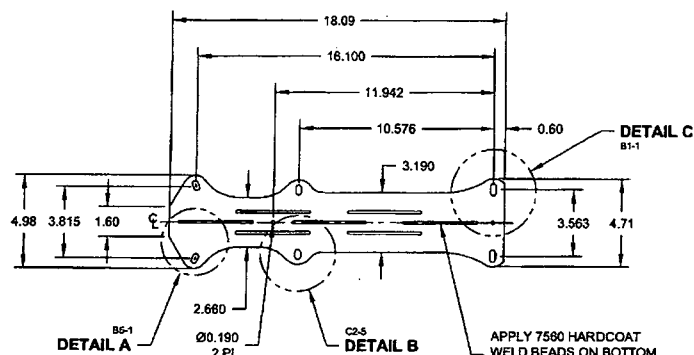
DART AEROSPACE LTD		Work Order:	114017
Description: Wearplate		Part Number:	D3319-1
Inspection Dwg: D3319 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

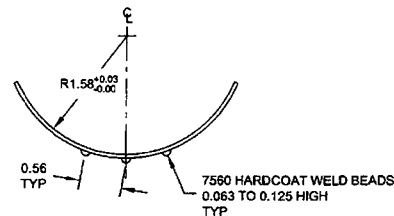
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.98	+/-0.030	4.983"	-		V	Jkmo1
1.600	+/-0.010	1.604"	-		V	
2.660	+/-0.010	2.664"	-		V	
3.190	+/-0.010	3.197"	-		V	
3.563	+/-0.010	3.564"	-		V	
4.71	+/-0.030	4.709"	-		V	
0.60	+/-0.030	0.607"	-		V	
10.576	+/-0.010	10.576"	-		V	Jkmo8
11.942	+/-0.010	11.942"	-		V	
18.09	+/-0.030	18.09"	-		T	Jkmo8
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	Ø0.316 x 0.546"	-		V	
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	Ø0.316 x 0.673"	-		V	
Ø0.190	+0.005/-0.001	Ø0.192"	-		V	
3.815	+/-0.010	3.815"	-		V	
16.100	+/-0.010	16.100"	-		T	

Measured by: Jm	Audited by: DAS 27	Preliminary Approval:
Date: 14-03-3	Date: 14/3/3	Date:

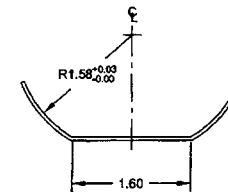
Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	



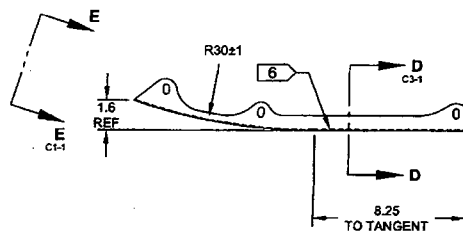
D3319-1F FLAT PATTERN



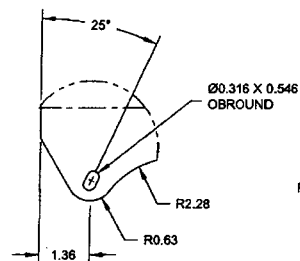
SECTION D-D
SCALE 4X



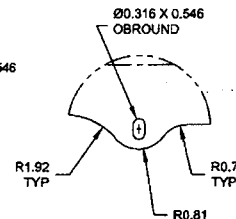
SECTION E-E
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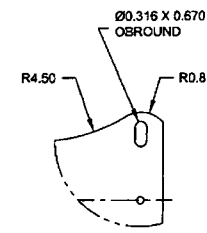
D3319-1 BENDING DETAIL
MAKE FROM D3319-1F



DETAIL A
SCALE 4X



DETAIL B
SCALE 4X



DETAIL C
SCALE 4X

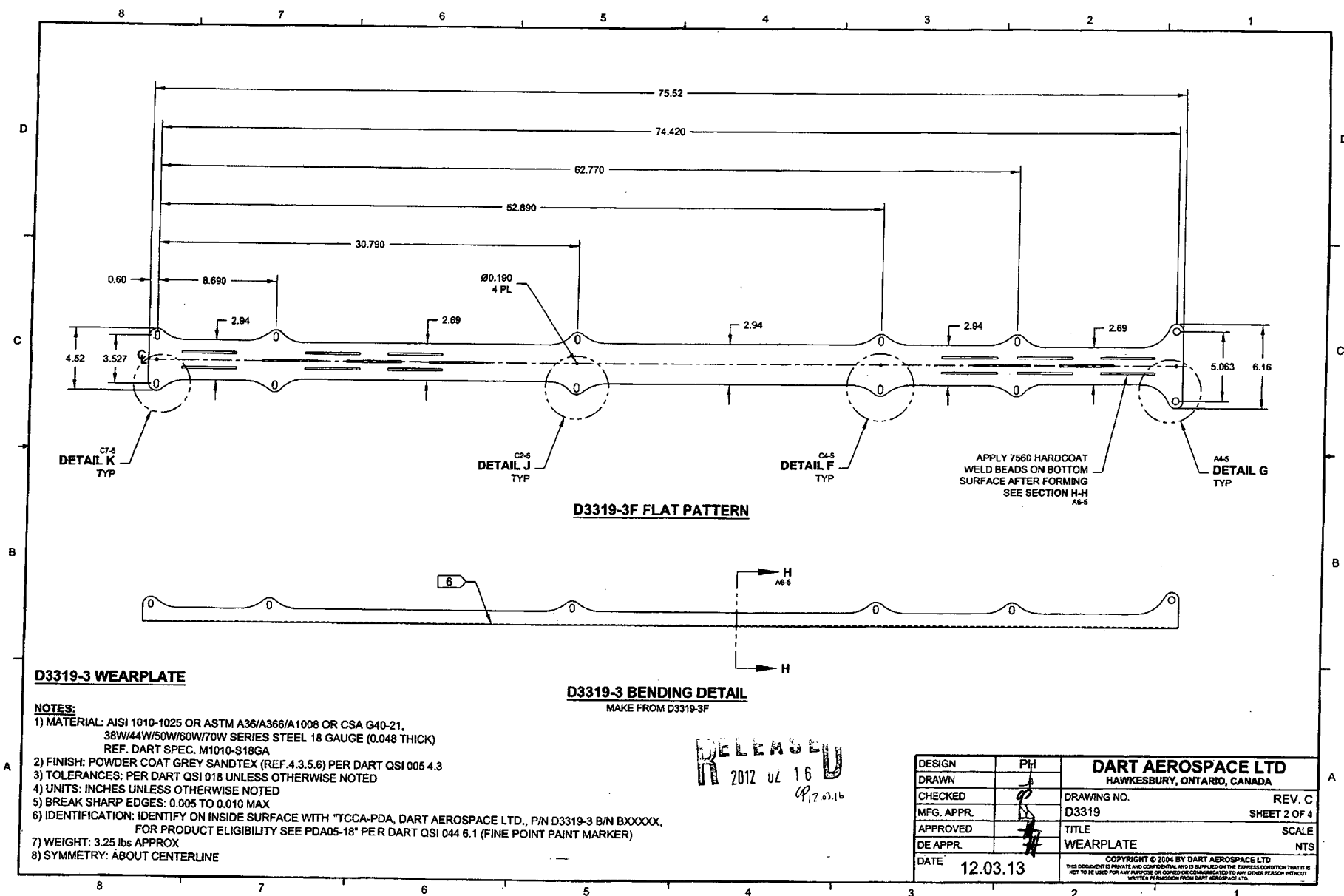
D3319-1 WEARPLATE

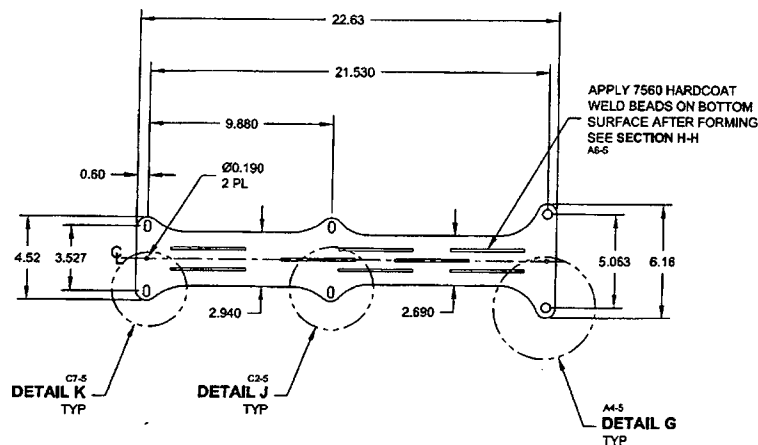
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

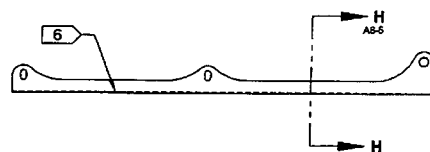
RELEASED
2012-03-16
PER ECN 12-946 12.03.16

C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT. MOST HOLE ON -3/-5-7 (REF DETAIL G). SEE NCR12-547.	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH ON -3/-5-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3319	SHEET 1 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		WEARPLATE	NTS
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ON ANY EQUIPMENT WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.03.13		



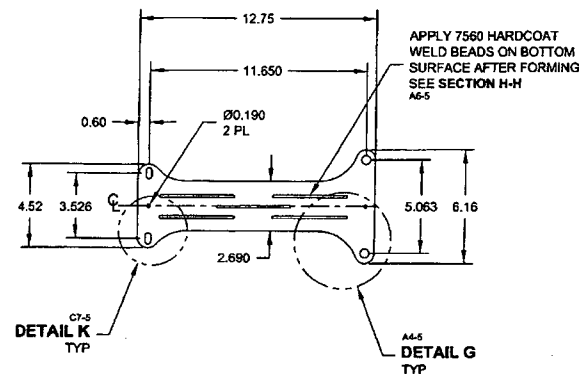


D3319-5F FLAT PATTERN

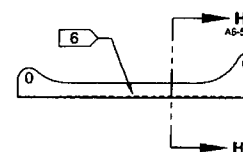


D3319-5 BENDING DETAIL

MAKE FROM D3319-5F



D3319-7F FLAT PATTERN



D3319-7 BENDING DETAIL

MAKE FROM D3319-7F





D3319-5/-7 WEARPLATE

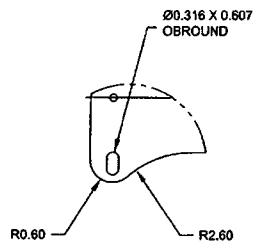
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 046 6.1 (PERMANENT MARKER)
- 7) WEIGHT: D3319-5 = 1.05 lbs APPROX; D3319-7 = 0.60 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

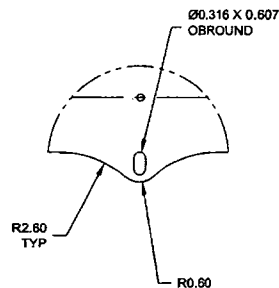
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2012-02-16

4/12/03/6

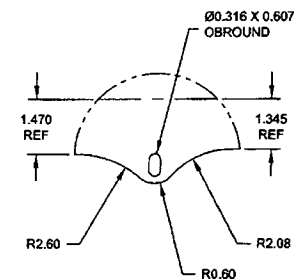
DESIGN	PH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3319	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	12.03.13	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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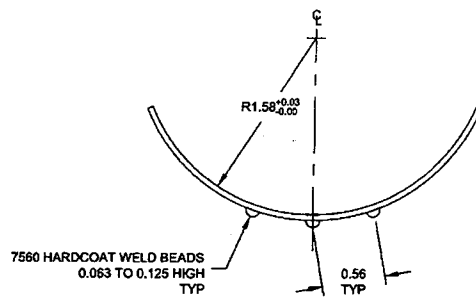
DETAIL K
SCALE 2X
B8-2
C4-3
C8-3



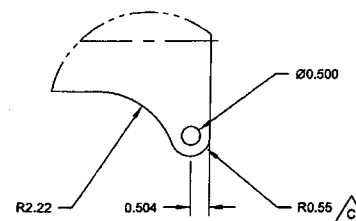
DETAIL F
SCALE 2X
B3-2



DETAIL J
SCALE 2X
B8-2
C7-3



SECTION H-H
SCALE 4X
B4-2
B3-3
B6-3



DETAIL G
SCALE 2X
B8-2
C2-3
C8-3

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MFG. APPR.	D	SHEET 4 OF 4	
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